

Work Order ID 69530

Wednesday, May 11, 2011 4:05:21 PM

Page 1

Item ID: D3537-1

Accept

Revision ID:



Item Name: Wearpad

Start Date: 5/11/2011 Start Qty: 50.00

Required Date: 5/16/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan: *N* Date: 11-05-12 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3537	Rev C
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100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-Deburr
if necessary

304.063

B11-5-13(57)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-5-13

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

811105113counts(157)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

Revision ID:

Item Name: Wearpad

Start Date: 5/11/2011 **Start Qty:** 50.00

Required Date: 5/16/2011 **Req'd Qty:** 50.00

Reference:

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Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □ 2-Identify as D3537-1

SB 11/05/18

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty.	Description	Batch	□A/R	2059B Hardcoat
118453	□1-Weld as per Dwg D3537 using Jig DT 8210			□2-Remove any weld that penetrated through Wearpad if necessary

X57 EL/JBL 11-08-18

150

QC10- Inspect visual per QSI004- ground welds

0.00

00000000000000000000000000000000

QC

Memo

0.00

Quality Control

6/10/17

count
(+57)

W/O:		WORK ORDER CHANGES					
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Work Order ID 69530

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Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 5/11/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 w/08/17

Quality Control

57
cents

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

9:30

320 01 FINISH TIME:

10:00

57XØ M-11/08/17

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

57 11/08/17

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Reference:

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Packaging	Identify as per dwg & Stock Location: <u>FR-1</u> Memo	0.00 0.00				<u>257</u>	<u>0</u>	<u>2608/17</u>	
200  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/8/18</u>	<u>21</u>
Quality Control									

11-08-17
(57)

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Picklist Print

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Work Order ID: 69530



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

201.4000

0.106

5.578947

6.1



1815-13

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

201.4

117275

41.4

117653

160

117275

(57)

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• **NOTE:** Date & initial all entries

SHOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

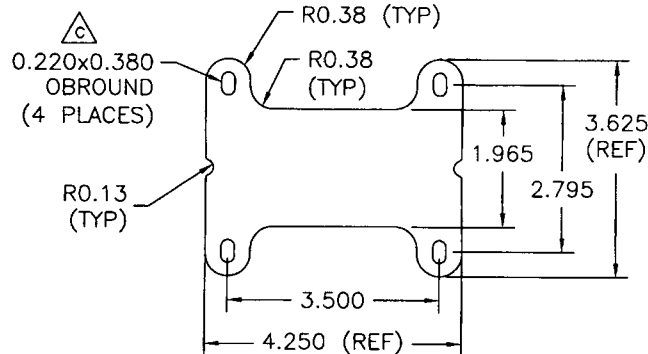
WITHOUT NOTICE

WORK ORDER

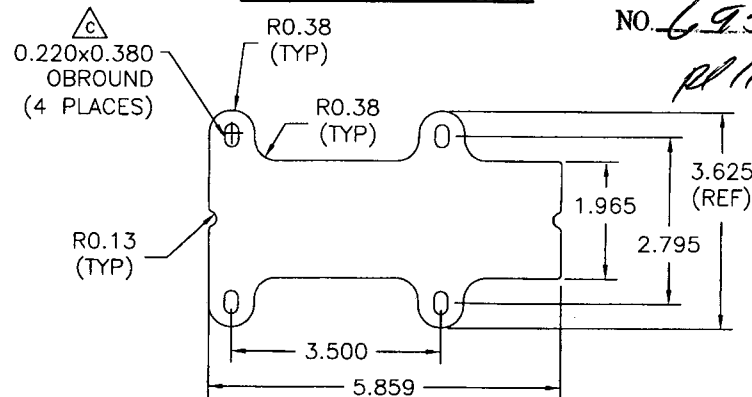
NO. 69530

11-05-12

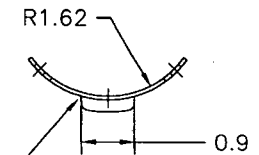
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

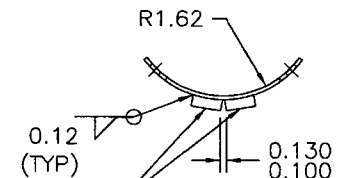


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B

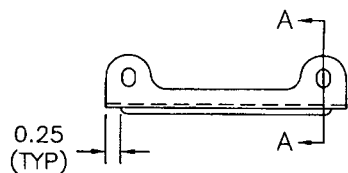


D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 PM
PER ECN
962

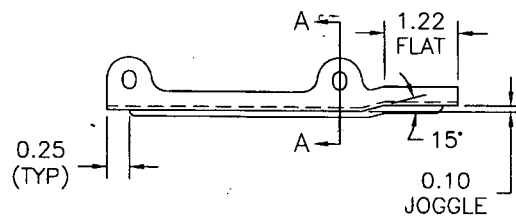
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



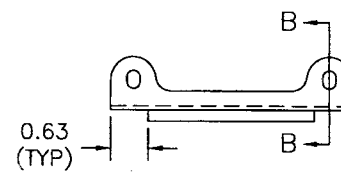
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)



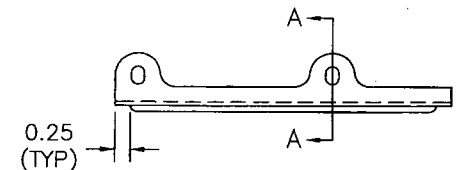
D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

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I put that in my CABINETS AT Home